

Work Order ID 62679

Wednesday, October 06, 2010 2:56:43 PM



Page 1

Item ID: D3065-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 10/6/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/10/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D
if necessary

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-Deburr

2004 . 046

B10-10-14

[Signature]

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

[Signature]

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Small Fab

Memo

Debur Stack

0.00

N/A

140



Brake NC

NC BRAKE

0.00

Brake NC

Memo

Bend as per Dwg D3065

0.00

SB 10/10/25

35

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

S 10/10/25

counted

735

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID:	D3065-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	10/6/2010	Start Qty:	30.00		Cust Item ID:	
Required Date:	10/15/2010	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				35	φ		
Hand Finishing									
170 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				35	φ		
Quality Control									
180 	Identify as per dwg & Stock Location	0.00							
Packaging	Memo	0.00							
Packaging									

-7 JH

10/16/27

BR 10-10-27.

35 φ

WA

10/16/27 φ (352)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, October 06, 2010 2:56:43 PM

Page 4

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Revision ID:

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Item Name: Step Spacer

Start Date: 10/6/2010 Start Qty: 30.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/28
MF
10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 2:56:47 PM

Page 1

Work Order ID: 62679

Parent Item: D3065-3

Parent Item Name: Step Spacer





Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	329.4400	0.2178	6.877895	7.7		
											1310-10-14		

Location

Loc Qty

Loc Code

MAT

84.2

114415

84.2

MAT22

245.24

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

129.3

113162

35

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42679
Description: Step Spacer		Part Number:	D3065-3
Inspection Dwg: D3065 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.258	x		V KB02	
3.260	+/-0.010	3.260	x		V	
5.260	+/-0.010	5.258	x		V	
6.520	+/-0.010	6.522	x		V	
2.093	+/-0.010	2.091	x		V	
3.936	+/-0.010	3.932	x		V	
4.186	+/-0.010	4.188	x		V	
Ø0.128	+0.005/-0.000	.132	x		V	
Ø1.250	+0.005/-0.000	1.254	x		V	
Pitch 1.204	+/-0.005	1.204	x		V	
0.040	+/-0.010	.042	x		V	

Measured by: JB	Audited by: J	Prototype Approval:	N/A
Date: 10-10-14	Date: 10/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	JE

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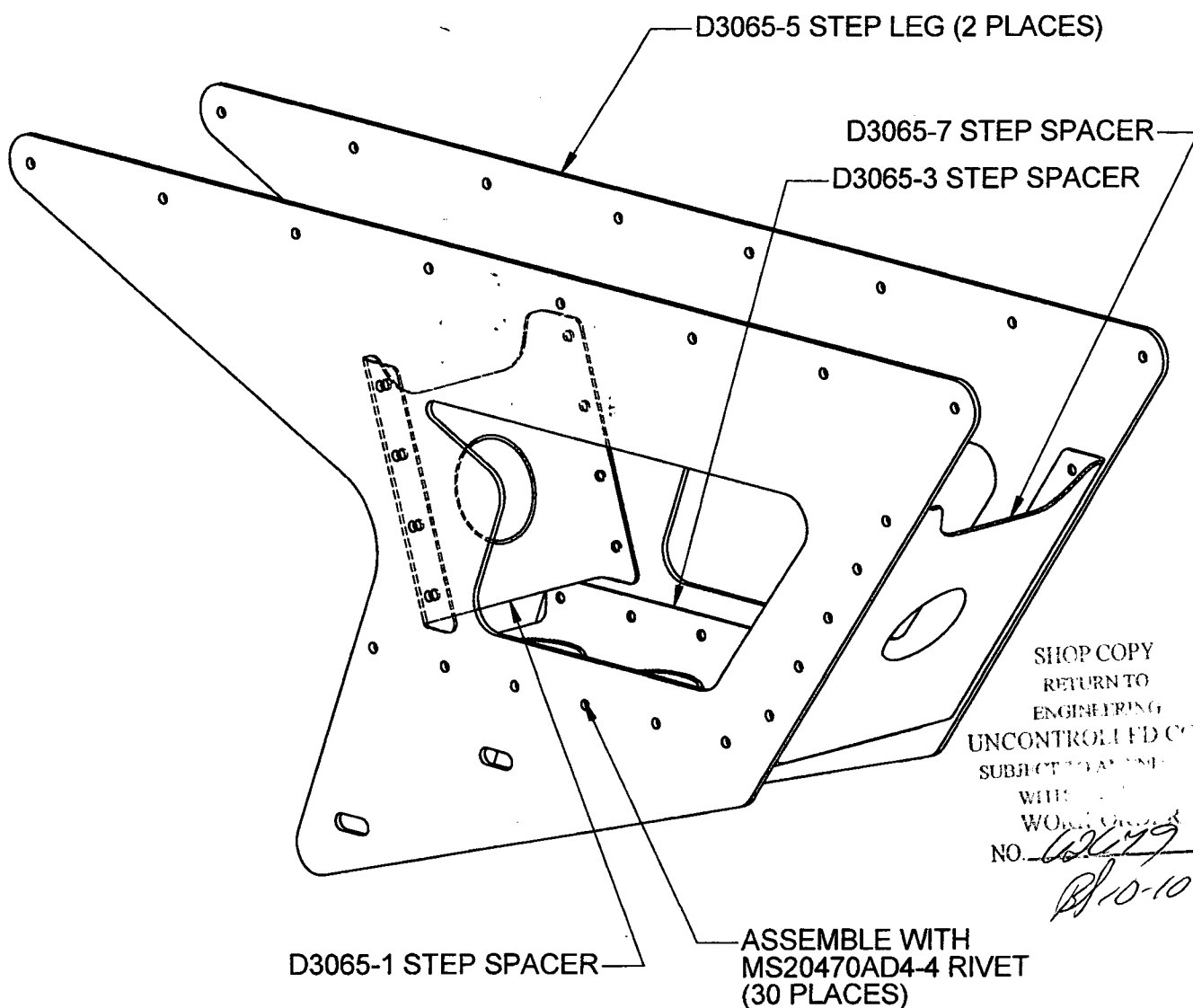
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

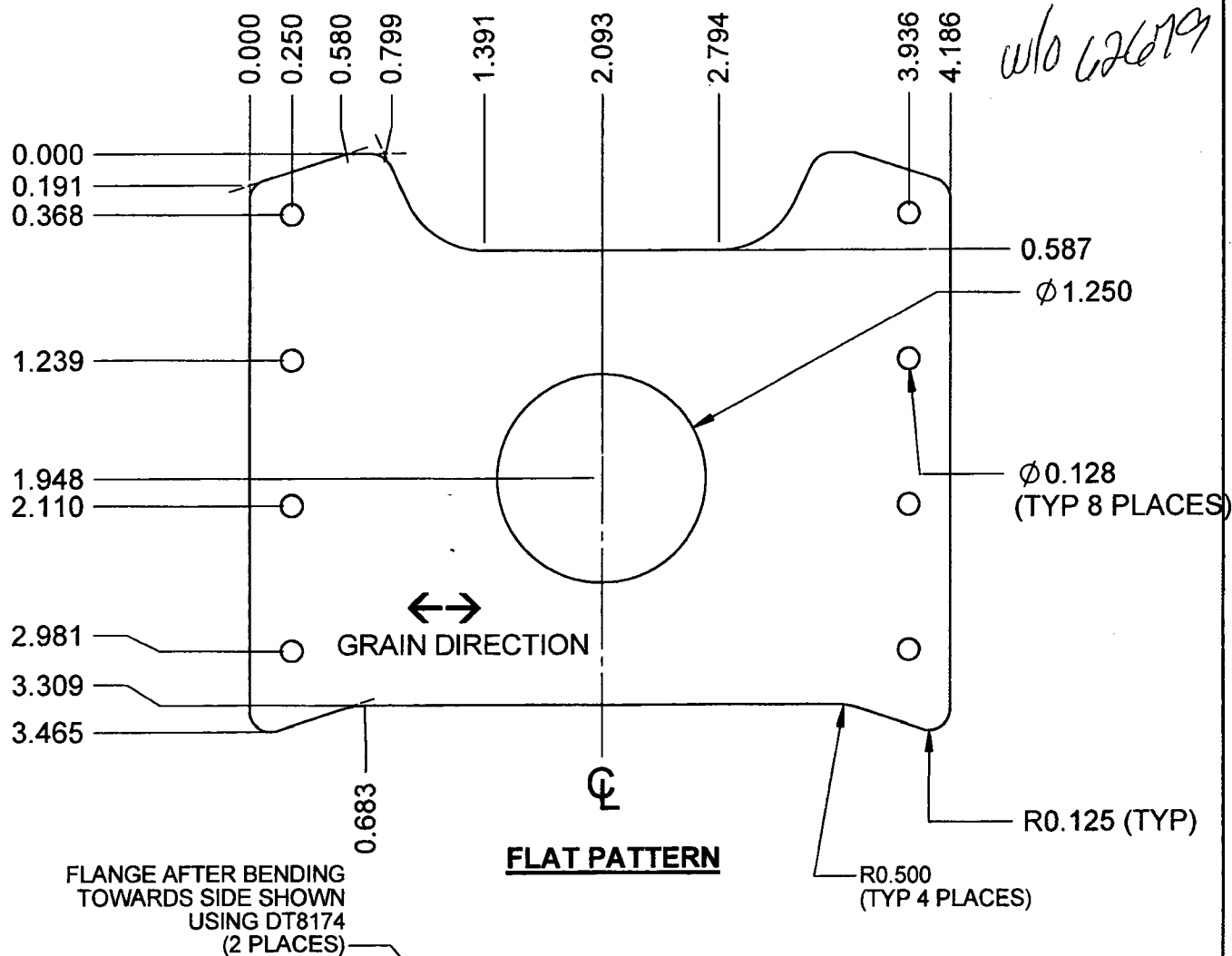
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

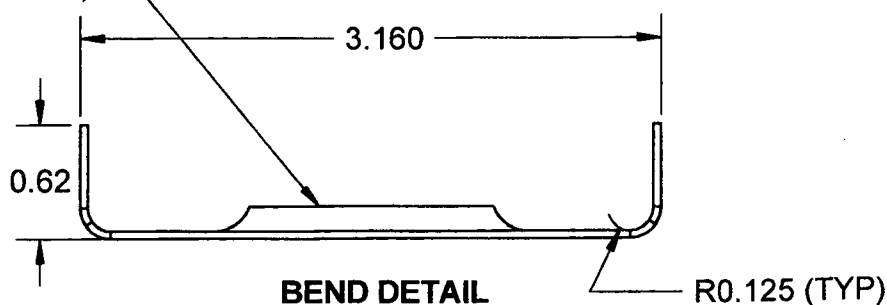


DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED

cl. de-20



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

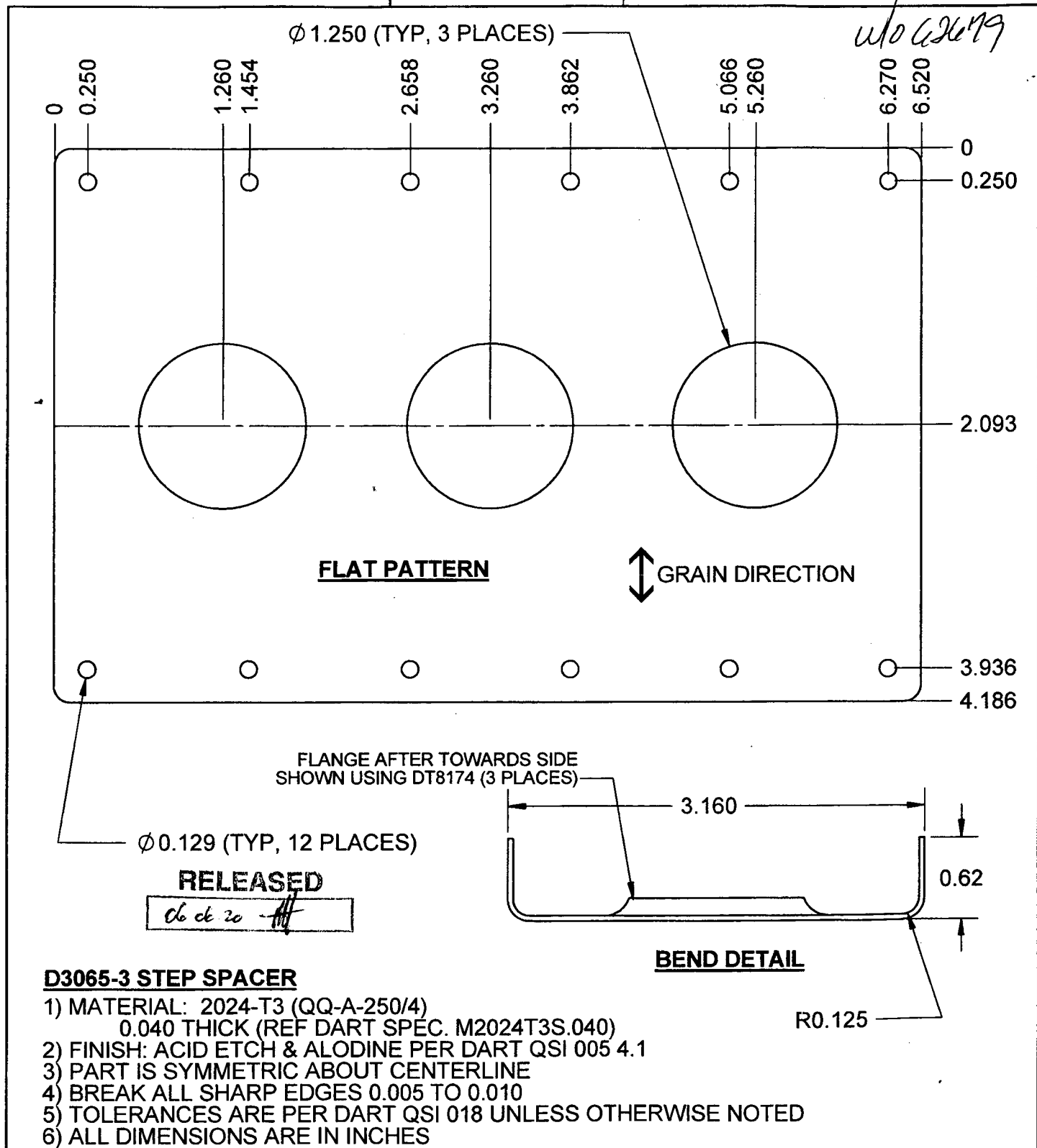
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



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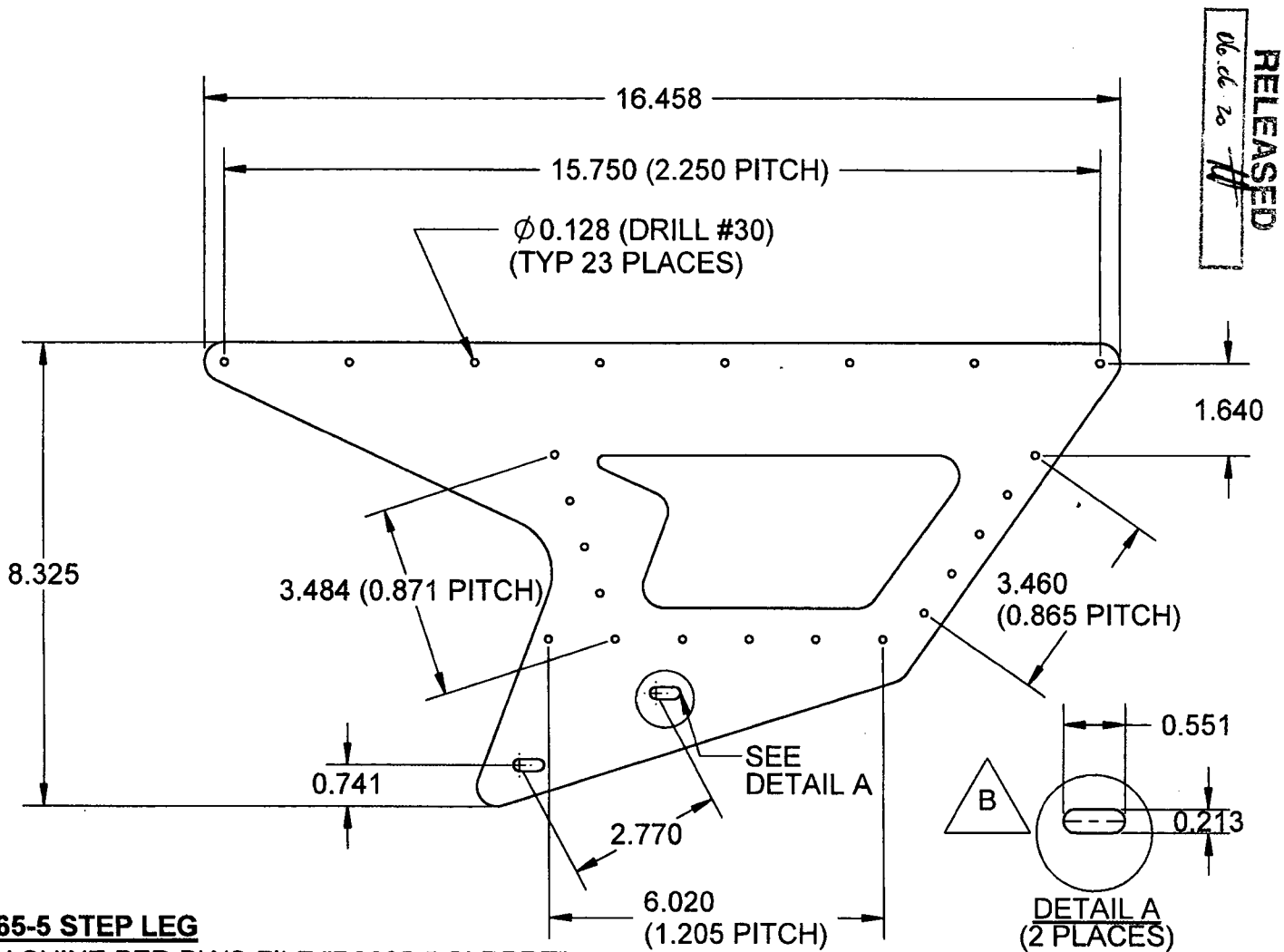
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. B
06.05.23		SHEET 4 OF 5
	TITLE	SCALE
	STEP LEG ASSEMBLY	1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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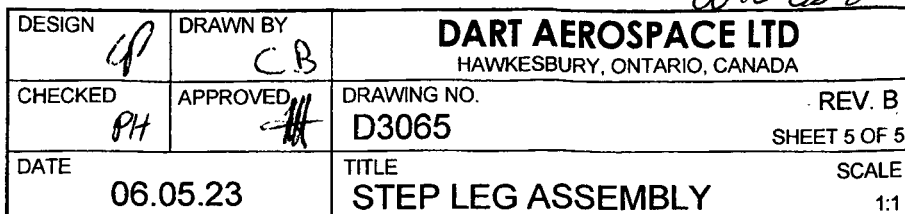
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NOTE: Date & initial all entries



RELEASED

de de 20

0.62

BEND DETAIL

- R0.125 (TYP)

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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